Qty:

: GUIDE

: D31373

: N/A

: E

: D3137 REV E

: 09/06/2008

Monday, 02/06/2008 10:41:18 AM

Jean-Luc Menard

**Process Sheet** 

**Drawing Name** 

**Part Number** 

Material

Due Date

Description:

**Drawing Number** 

Project Number

**Drawing Revision** 

: CU-DAR001 Dart Helicopters Services Customer

Job Number : 39628 : 11073 Estimate Number

P.O. Number

: 02/06/2008 This Issue

: NC

Prsht Rev. : // First Issue

: 39449 Previous Run

Written By

**Checked & Approved By** 

Comment

02.05.29 : Est Rev:A

Type

S.O. No. :

New Issue NG

08-05-23 revE as per dwg DD verified by:EC Est Rev:B

MACHINED PARTS

**Additional Product** 

Job Number:



Seq. #:

2.0

3.0

4.0

**Machine Or Operation:** 

Delrin Bar

MDELRINB075X1250 1.0



Comment: Qty.: 0.0831 f(s)/Unit Total:

1.6611 f(s)

Matl:Black Delrin bar 1.250" x .750"

(ref DART spec. M-DELRIN-B)

Batch: MHS35 BAND SAW

BAND SAW



Comment: BAND SAW

Cut Blanks.Blank size: 1.250" x .750" x .950" long

HAAS CNC VERTICAL MACHINING #1 HAAS1





Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA242 & Dwg D3137

2-Deburr

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8

SECOND CHECK



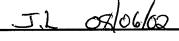
Comment: SECOND CHECK



20 Um:

Each



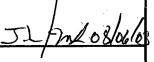




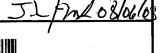




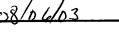




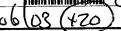












Date: /User:

Monday, 02/06/2008 10:41:18 AM

Jean-Luc Menard

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 39628

Part Number: D31373

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



7.0

QC21

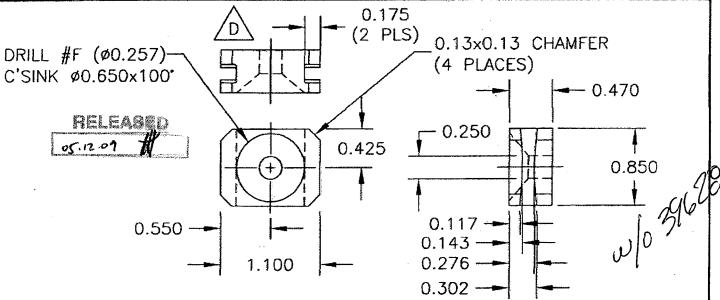
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



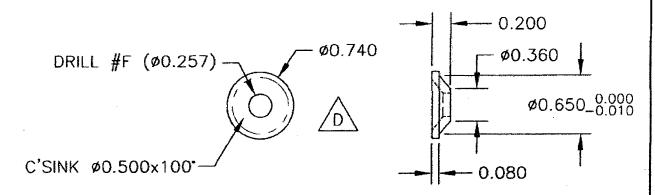


4	DESIGN DS	drawn by RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
-	CHECKED M	APPROVED	DRAWING NO.	REV. E	
i	一個一	T	D3137	SHEET 3 OF 5	
	DATE		TITLE	SCALE	
	05.11.23		BRACKET ASSEMBLY	1:1	



## D3137-3 GUIDE

- 1) REPLACES PREMIER P/N B30-23000-207
- 2) MATERIAL: DELRIN BAR (REF DART SPEC. M-DELRIN-B)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL EDGES 0.005 TO 0.015



## D3137-5 WASHER

- 1) REPLACES PREMIER P/N B30-23000-209
- 2) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) BAR (REF DART SPEC. M6061T6R)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL EDGES 0.005 TO 0.015

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DART AEROSPACE LTD	Work Order:	39628
Description: Guide	Part Number:	D3137-3
Inspection Dwg: D3137 Rev: E		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.175	+/-0.010	. 175				
Ø0.257	+0.005/-0.000	. 258				
Ø0.65 x 100°	+/-0.030	659 X100°				
0.425	+/-0.010	.425				
0.550	+/-0.010	.550	/			
1.100	+/-0.010	1.101				
0.470	+/-0.010	469				
0.850	+/-0.010	.852				
0.143	+/-0.010	. [4]				
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Measured by:	J.L.	Audited by:	DIP	Prototype Approval:	N/A
Date:	08/06/02	Date:	8 6 blo3	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.11.27	New Issue	KJ/RF	
В	04.11.12	0.175 was 0.145 & Ø0.65 x 100° was Ø0.75 x 100°	KJ/JLM	21
С	06.03.15	Dwg Rev update	KJ/JLM OX	